

Date: Thursday, 6/15/2006 1:45:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 27575A	Part Number	: D2221
Estimate Number	: 10189	Drawing Number	: D2221/D2235
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/15/2006	Drawing Revision	: F/B1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 7/5/2006
Previous Run	: 27521A	Qty:	1
Written By	: <i>See Log Comment Below</i>	Um:	Each
Checked & Approved By	: <i>06 06 15 M</i>		
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		<i>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)</i>	<i>06/06/21 0</i>
		Pick:	
		Qty Part Number Description Batch	
		4 D3166-1 RIB <i>B21326</i>	
2.0	D22323	Basket Hinge	
		<i>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</i>	<i>06/06/26 0</i>
		Pick:	
		Qty Part Number Description Batch	
		2 D2232-3 Hinge bracket <i>B21527</i>	
3.0	D2325	Support Gusset (350 Bask)	
		<i>Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)</i>	<i>06/06/26 0</i>
		Pick:	
		Qty Part Number Description Batch	
		4 D2325 Support Gusset <i>B26741</i>	
4.0	D23273	Spacer Bushing	
		<i>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</i>	<i>06/06/26 0</i>
		Pick:	
		Qty Part Number Description Batch	
		2 D2327-3 Bushing <i>B27051</i>	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:45:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27575A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket B27524

M 06/06/26 @

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim B26739

M 06/06/26 @

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch
36 sf M304EX0.75-16F Expanded Metal M101358

M 06/06/26 @

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M101309

M 06/06/26 @

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

M 06/06/26 @

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/06/30

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:45:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27575A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION

PD 06-06-27 ①



Comment: DDIMENSIONAL & WELDING INSPECTION

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-06-27

①

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.W 06-06-28 ②

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M101193

Expiry date: 11/2006

H.M 06-06-28

①

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/30 ①

Job Completion



W 06/06/29

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

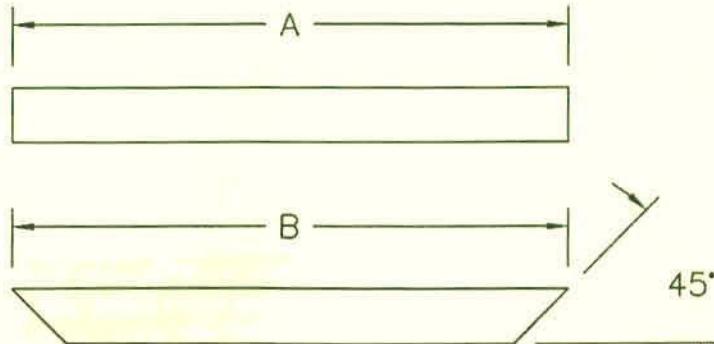
RELEASED

05.08.19 *H*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM

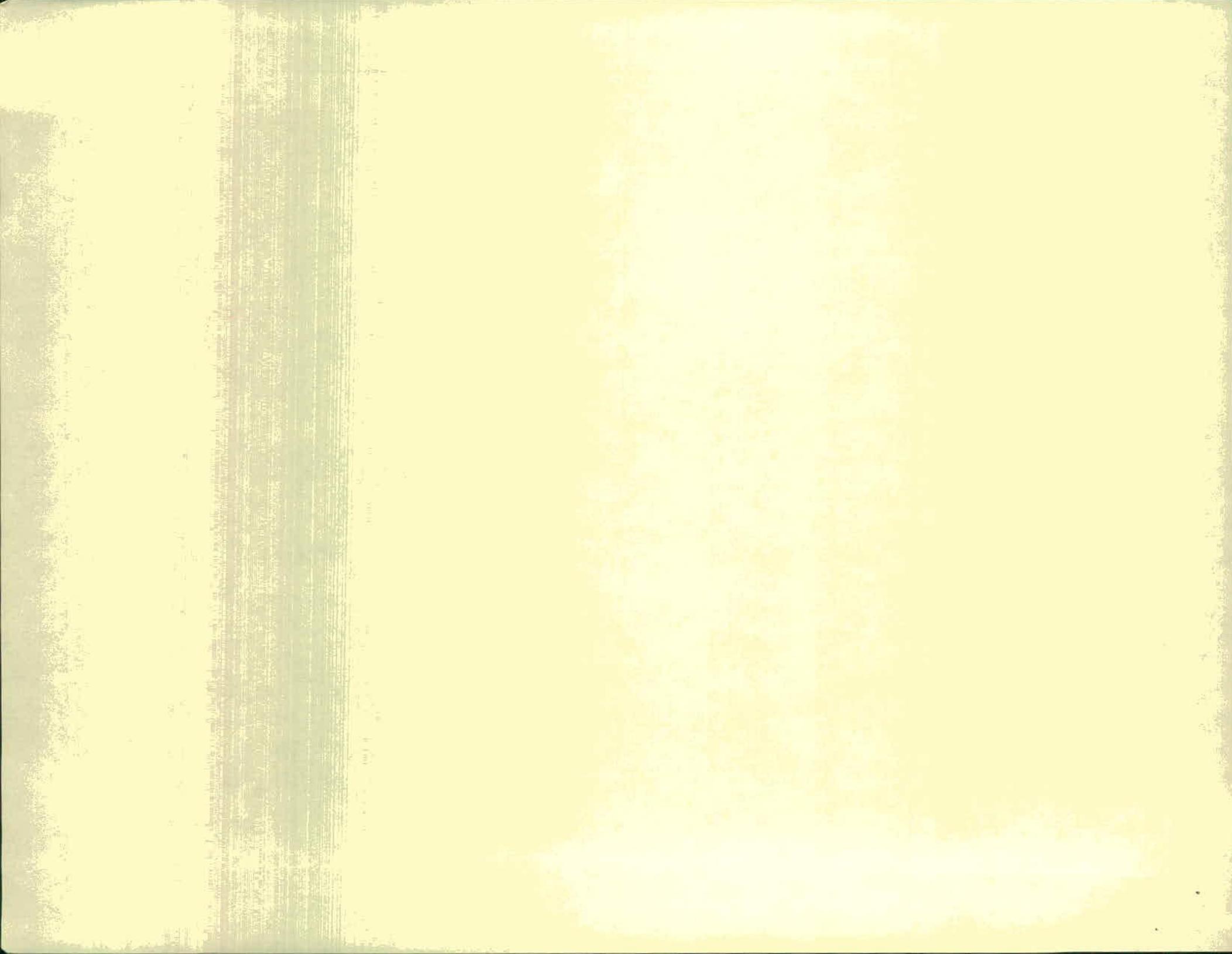
D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

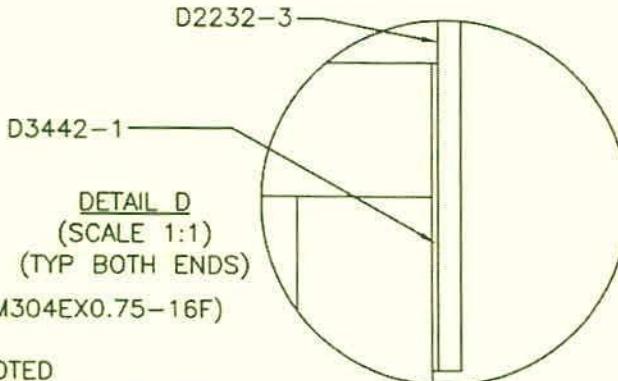
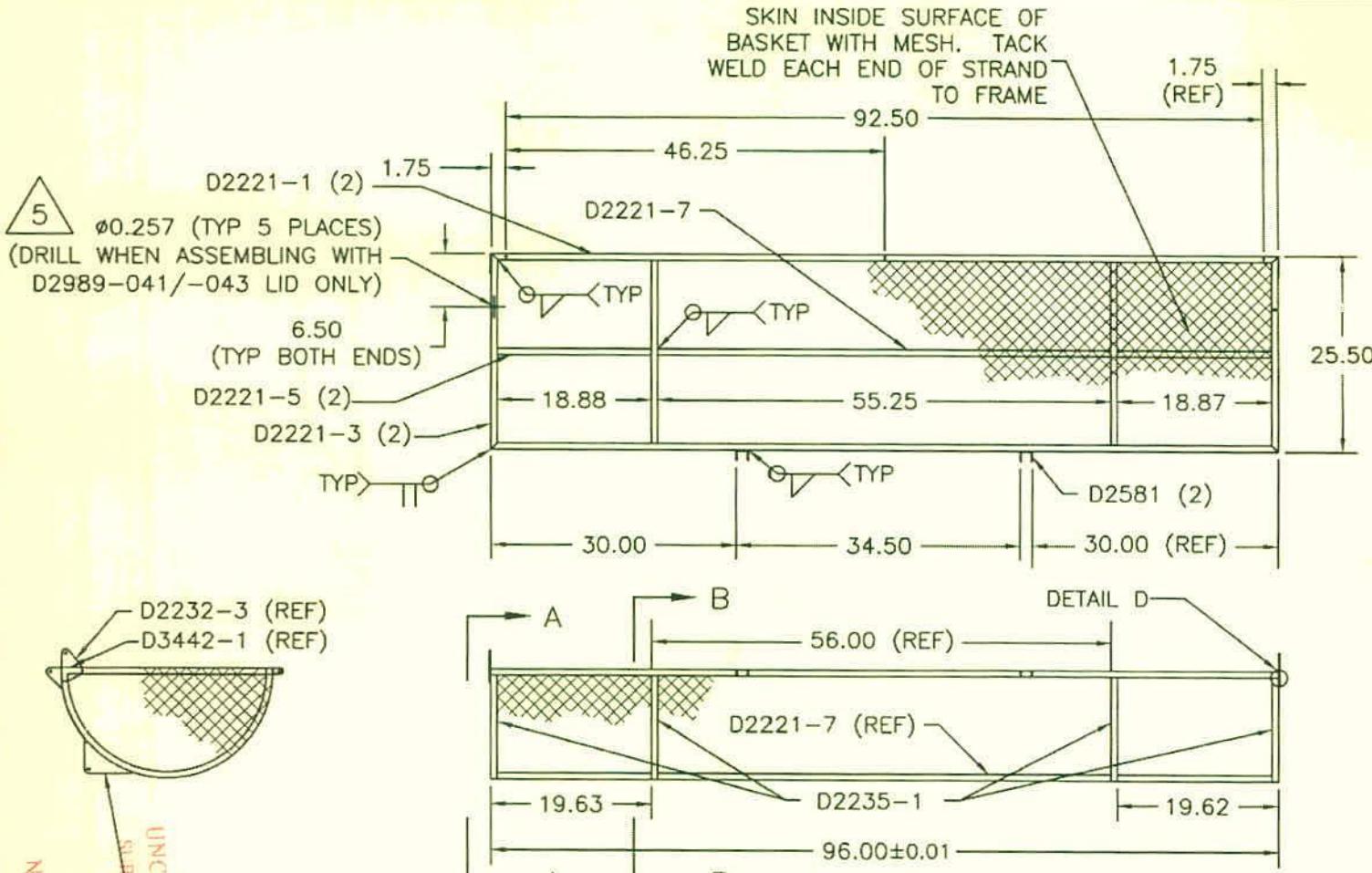
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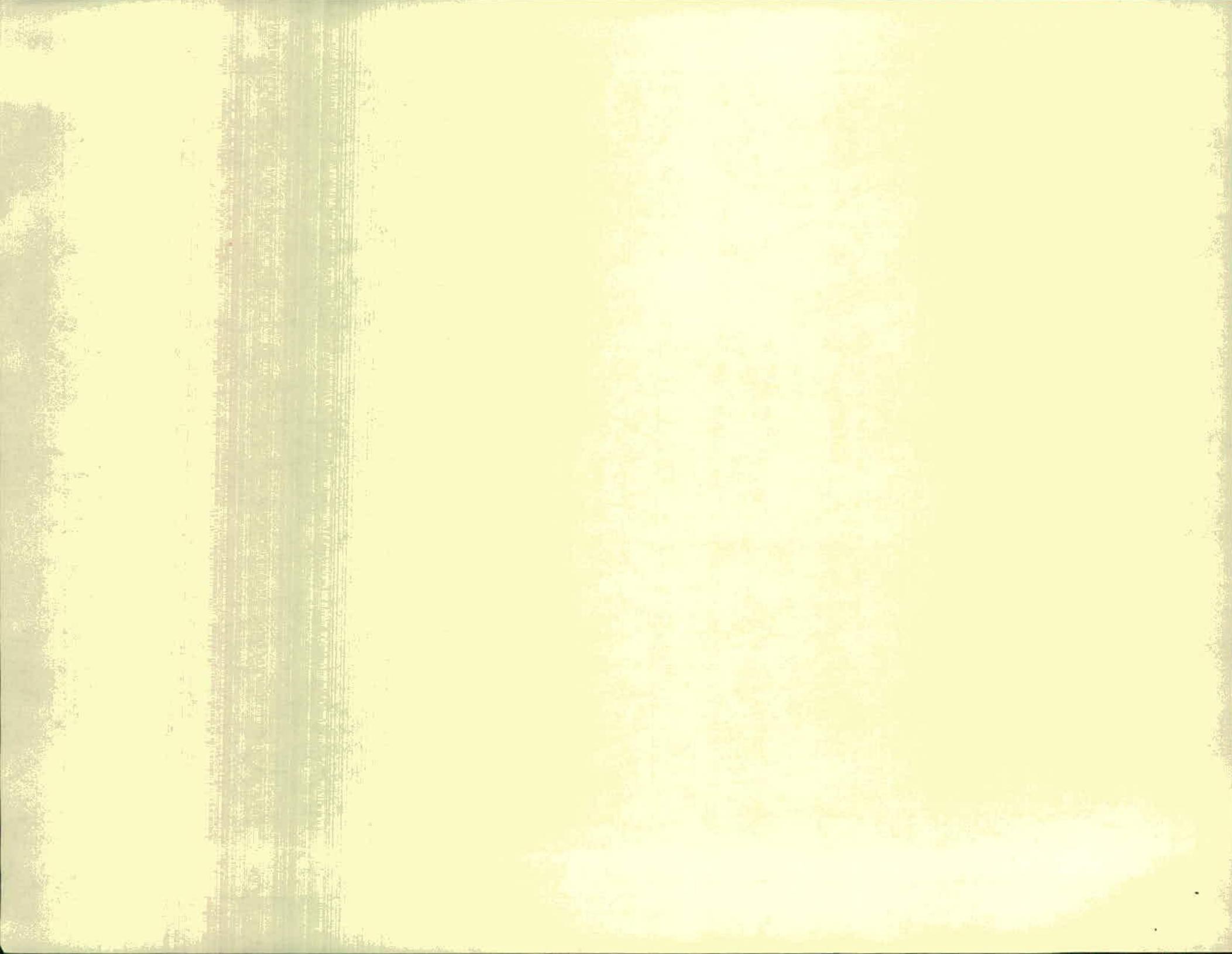


D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

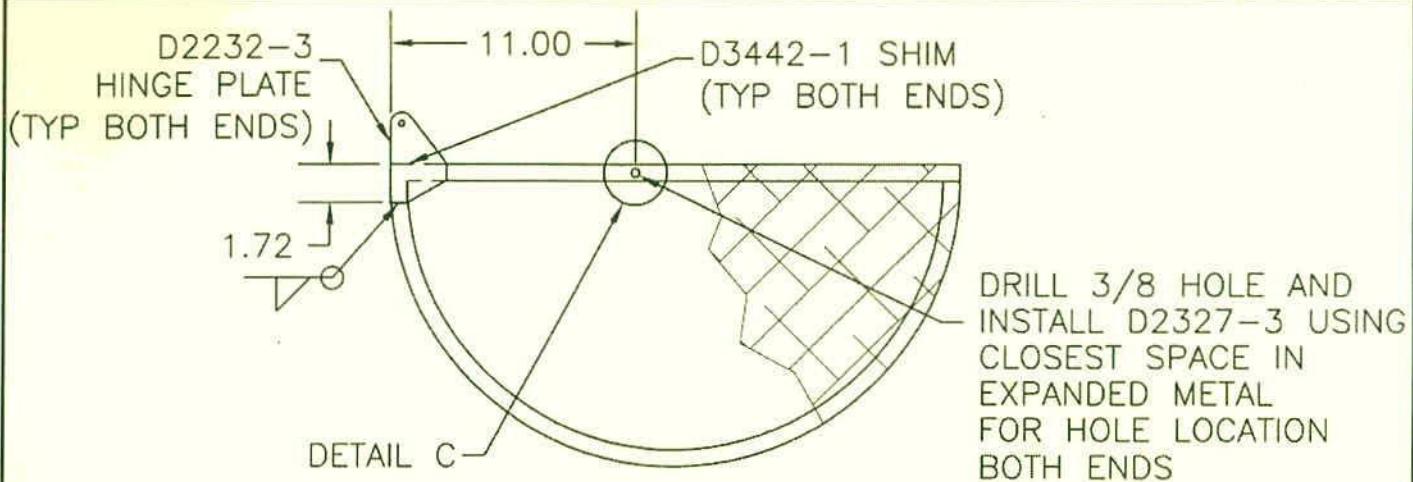
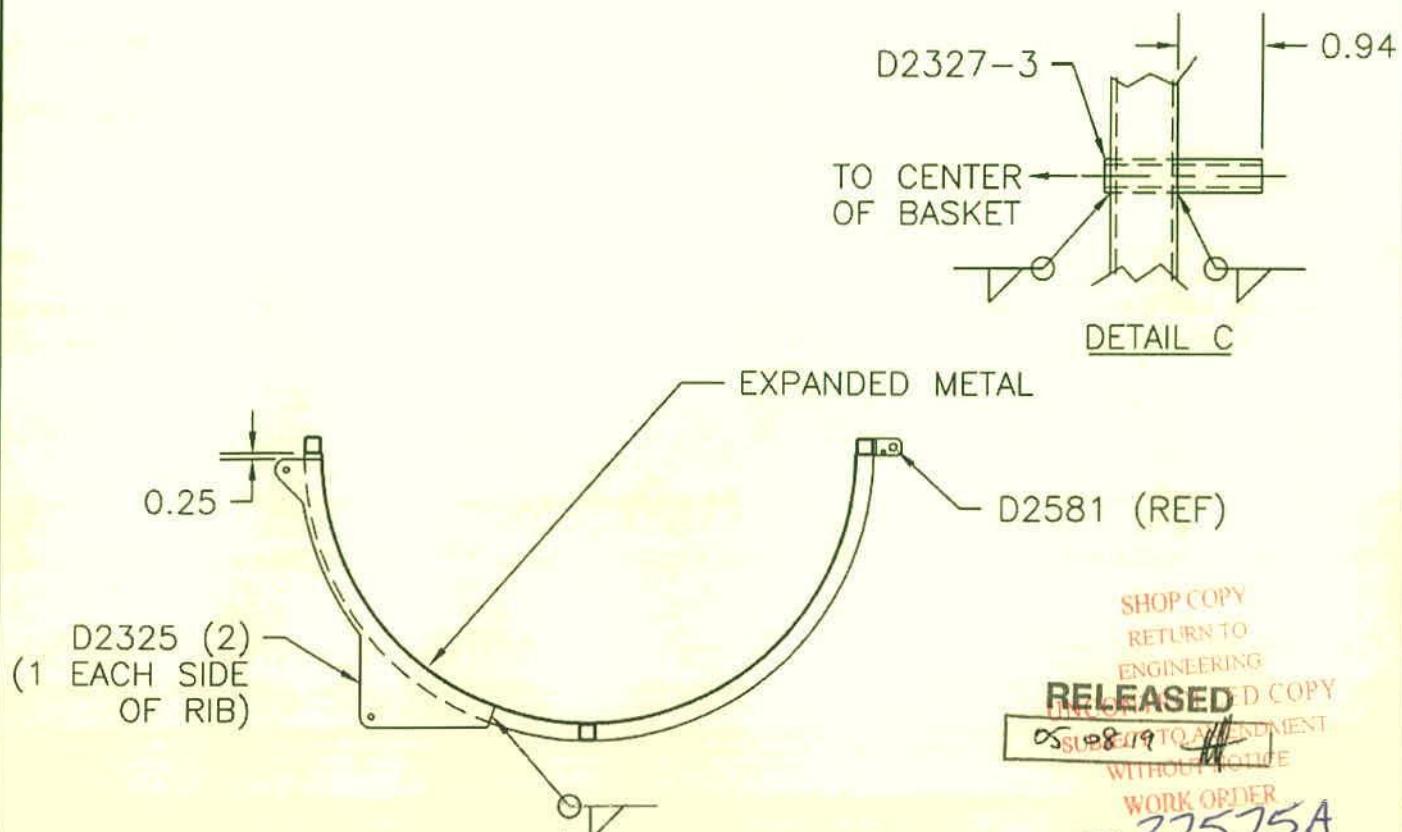
DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. D2221
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3 REV. F SCALE 1:20



DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

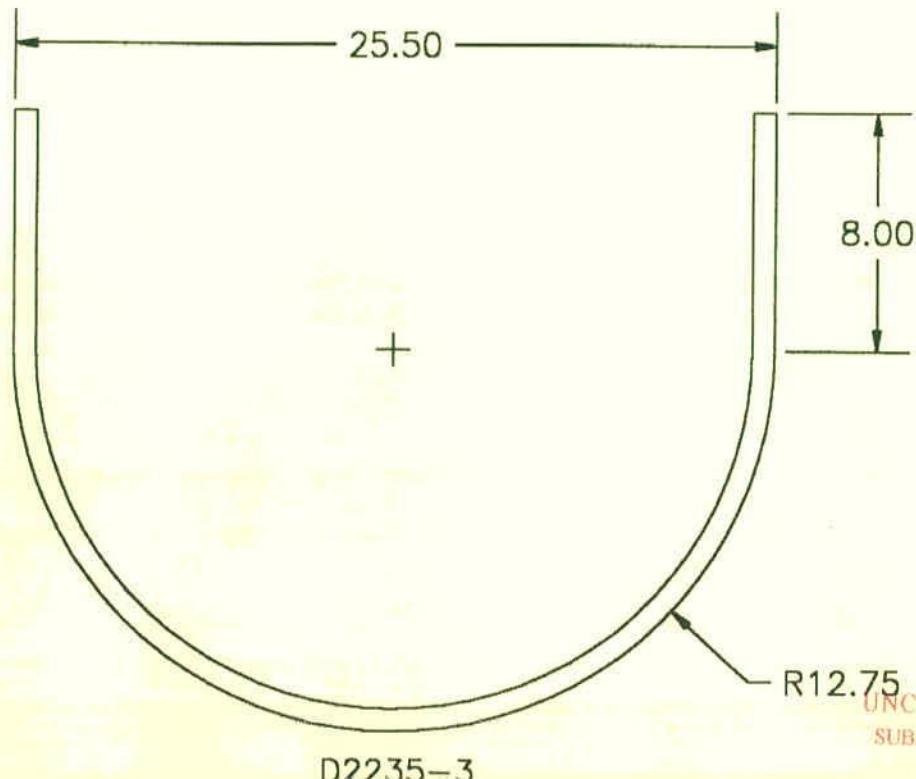
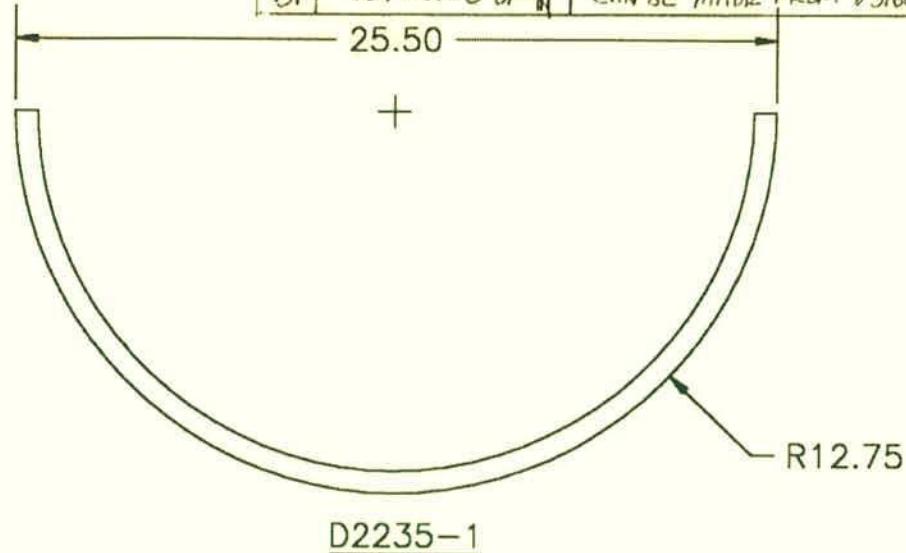
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DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

BI 02.08.06 (P) CAN BE MADE FROM D3166-1

RELEASED
 960507


CAN BE MADE FROM D3166-1 BI
 MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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